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INFORMATION REPORT INFORMATION REPORT

CENTRAL INTELLIGENCE AGENCY

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OUNTRY	USSR (Moscow Oblast)	REPC	ORT				7
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COUNTRY:	US	SR (Moscow	Oblast)	REPORT		
SUBJECT:	Mos Pla	scow Ball Beant No. 1	earing	DATE OF		
				DATE AC		
				DATE OF REPORT	[:] 23 June 1960	50X1-HUM
			MOSCOW B	ALL BEARING PLAN		X1-HUM
1.						
	D 2					
2.		nt producti			d. 4domakon .	
	a)	factured i	ngs less t n a restri	han 16 millimete: cted shop	rs in diameter i	50X1-HUM
	b)	side diame not more t	ter of 20 han one hu here was o	t 15 millimeters to 70 centimeter ndredth of a mil ften a shortage	s.¹ A tolerance limeter was per	of
					50X1-HUN	Л
			Q-O-N-F-	I-D-E-N-T-I-A-L		

3.

a large part of production
went to the ZIS Plant in Moscow.

50X1-HUM

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C-O-N-F-I-D-E-N-T-I-A-L

50X1-HUM

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COUNTRY:	IISSR (Mos	kovskaya obl	ast) REPO	RT		
SUBJECT:		on of the Sec				
SOBJECT.		n of the Sec 1 Bearing Pl	- O.L. W.			
			DATE	A		
			DATE	OF REPORT:	30 June 1960	50X1-HUM
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	PRODUCTIO	ON OF THE SEC	COND STATE BALL	BEARING PLAI	NT	50X1-HUM
	PRODUCTIO	ON OF THE SEC	COND STATE BALL	BEARING PLAI	NT	50X1-HUM
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	PRODUCTIO	ON OF THE SEC	COND STATE BALL	BEARING PLAI	NT:	50X1-HUM
	machin	ed outer bes	aring rings			
had the :	machin following d	ed outer bes imensions:	ring rings outer diameter	- 18 millime		ameter -
15 milli	machin following d	ed outer bes imensions: ckness - fiv	aring rings	- 18 millime		Lameter - 50X1-HU
had the : 15 milli	machin following d neters; thi	ed outer bes imensions: ckness - fiv	aring rings outer diameter re millimeters.	- 18 millime	eters; inner di	Lameter - 50X1-HU
15 milli	machin following d neters; thi	ed outer bes imensions: ckness - fiv were:	ring rings outer diameter e millimeters. Inner	- 18 millime Other s	eters; inner di sizes of outer Thickness	ameter - 50X1-HU
15 milli	machin following d neters; thi Outer dia	ed outer bes imensions: ckness - fiv	ring rings outer diameter e millimeters. Inner	- 18 millime	eters; inner di sizes of outer Thickness	ameter - 50X1-HU
rings Largest s	machin following d meters; thi Outer dia size size	ed outer besimensions: ckness - fiv were: meter 60 millime 6-7 millim	ring rings outer diameter e millimeters. Inner	Other s diameter millimeters millimeters	eters; inner di sizes of outer Thickness 10 millime 1 millime	ameter - 50X1-HU bearing
15 millings rings Largest s Smallest The autor	machin following duters; this outer diasize size matic latherake automat	ed outer besimensions: ckness - fiv were: meter 60 millime 6-7 millim	ring rings outer diameter re millimeters. Inner reters 40 meters 3-4 med an unknown	Other s diameter millimeters millimeters number of So	eters; inner di sizes of outer Thickness 10 millime 1 millime	sters ters ters ters ters ters ters
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which types. One lathe operator serviced three to five lathes. The ball 50X shep also had two furnaces for heat treatment and an unknown number of presses, polishing machines, and grinding machines. The ball shop employed about 150 workers on the first shift, 100 on the second, and about 50 on the third. during the first shift the ball shepproduced about 50 steel boxes of bearing balls. The steel boxes, which were about 40 x 20 x 15 centimeters in dimension, each contained 25 kilograms of bearing balls. The total estimated produced about 30 to 35 boxes representing a total of about 850 kilograms of bearing balls. The third shift produced about 25 boxes, a total of about 625 kilograms. The total average daily (24-hour) production was three or four tons, or about 80 to 100 tons of bearing balls per month. The balls were manufactured in sizes from one millimeter to three millimeters in diameter. OTK Inspection Procedures The bearing balls were inspected after the pressing, polishing, heat treating, and grinding production phases.	50X1-HU
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These rejects were placed in four-kilogram capacity cardboard boxes, 1) x 10 x centimeters in dimension, and were later reinspected and reprocessed.	•
centimeters in dimension, and were later reinspected and reprocessed.	
	50X1-HU
The finished bearings were packed in wood	.en
boxes 50 x 30 x 20 centimeters in dimension and shipped by truck to unknown destinations.	
Coument:	
	50X1-HL
1.	
inspection of the bearing balls produced in the ball manufacturing	
shop was performed at the end of each production phase with the use of	
micrometers and other measuring instruments, and later the bearing balls were X-rayed in the shop on the floor above the ball manufacturing shop.	
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